

Work Order ID 130303

Wednesday, March 04, 2015 11:45:41 AM

130303

Page 1

Item ID: D2230-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mounting Lug *10.*
Start Date: 3/4/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 3/13/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference: REPAINT

Approvals: Process Plan: UMF Date: 15-3-4 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2230	Rev G

200

0.00

200

QC

Quality Control

Memo

0.00

PULL FROM RA111945
D2230-3 X 4 B116379

2 x 116378
~~STRIP AND REPOWDER COAT~~

scuff

210

Chemical Conversion Coat per OSI005 4.1

0.00

210

HandFinish

Hand Finishing

Memo

0.00

15-3-5
~~STRIP AND REALODINE~~

220

QC7-Inspect Chemical Conversion Coat

0.00

220

QC

Quality Control

Memo

0.00

10 *15-03-05* *DAS 9 9-89*

10 *15-5-6* *JMIS-5-6*

10 *15-5-12* *DAS 34 9-89*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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Revision ID: Stop ***NS2***
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Start Date: 3/4/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 3/13/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference: REPAINT

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 *230* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 131545</i> Memo START TIME: <i>10:35</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>11:05</i>	0.00 0.00				<i>10</i>	<i>0</i>	<i>15-5-12</i>	<i>888</i>
240 *240* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>(10)</i>			<i>DAG</i> <i>38</i> <i>8-89</i> MAY 12 2015
250 *250* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00				<i>10</i>	<i>27</i>		<i>DAG</i> <i>27</i> <i>8-89</i> MAY 12 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 130303***130303***

Page 3

Wednesday, March 04, 2015 11:45:41 AM

Item ID: D2230-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Mounting Lug

Start Date: 3/4/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 4.00

4

Customer:

Reference: REPAINT

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC21 - Final Inspection - Work Order Release

0.00

260

QC

Memo

0.00

Quality Control

MAY 13 2015

MCS

MAY 13 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Wednesday, March 04, 2015 11:45:41 AM

Page 1

Work Order ID: 130303

130303

Parent Item: D2230-3

D2230-3

Parent Item Name: Mounting Lug

Start Date: 3/4/2015

Required Date: 3/13/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP D00.05.18Added inspection level 8, and removed P/O for powder
coatEC IPP REV :E NEW FOLIO # 10-05-
25 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2230-3		Manufactured	No				Each	31.0000		4			
---------	--	--------------	----	--	--	--	------	---------	--	---	--	--	--

D2230-3

**

Mounting Lug

Location

Loc Qty

Loc Code

FG	8	
109344	4	
89045	4	
ST521	23	
114921	3	
116378	1	
123324	19	

4 x 116378
MF 15-13-4
6 x 116378

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

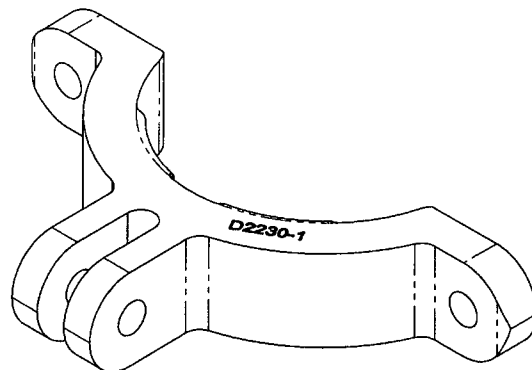
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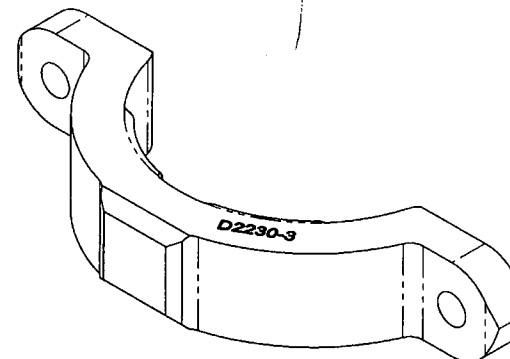
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		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED
01/06/15 M

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.			AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100			CP	99.12.13
E	RE-DESIGN			BW	95.01.04
D	RE-DESIGN			BW	95.01.04
C	RE-DESIGN			BW	94.03.30
REV.		DESCRIPTION		BY	DATE
DESIGN		BW		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		AJS			
CHECKED		DRAWING NO.		REV. G	
MFG. APPR.		D2230		SHEET 1 OF 3	
APPROVED		TITLE		SCALE	
DE APPR.		MOUNTING LUG		NTS	
DATE		09.01.16			
COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.					



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

DQA: _____ Date: _____



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